

Work Order ID 92120 - 1

Tuesday, October 23, 2012 4:11:59 PM

\*92120\*

Page 1

Item ID: PB67-43001-11

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-11	Rev C								

100

\*100\*

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg
- 3- grind weld flush in area of PB67-43001-249 only
- 4- install helicol insert as per dwg

(4x)

CC 12-12-4

110

\*110\*

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

4

12-12-05

DAS  
18

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Item ID: PB67-43001-11

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop \*NS2\*

Start Date: 10/23/2012 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

\*150\*

HandFinish

Memo

0.00

Hand Finishing

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

\*160\*

Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:  
OVEN TEMPERATURE: 320°F FINISH  
TIME: 2:45

3:15

ML6144

4X6

MT

12/12/10

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Item ID: PB67-43001-11

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop

\*NS2\*

Start Date: 10/23/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 11/2/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

4 0 12/2/10 23

180

0.00

\*180\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1-match drill-cover to existing holes in support 2-assemble as per dwg

12 23 12-12-19

190

QC5- Inspect part completeness to step on W/O

0.00

\*190\*

QC

Memo

0.00

Quality Control

12/2/12

1

**Work Order ID 92120**

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**\*92120\***

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Item ID: PB67-43001-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop **\*NS2\***Start Date: 10/23/2012 Start Qty: 4.00 **\*4\***Required Date: 11/2/2012 Req'd Qty: 4.00 **\*4\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <i>WMA</i>	0.00							
<b>*200*</b>									
Packaging	Memo	0.00				1	<i>⊕</i>		<i>12-12-19</i>
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							<i>MCS 12-12-19</i>
Quality Control									

*W121219*

# Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec IPP Rev B 10.09.27 per revC  
dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
[REDACTED]		Manufactured	No		B93495 = 4		Each	1.0000		4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				85187		1							
[REDACTED]		Manufactured	No		B90926 = 4	100	Each	0.0000	1	4		11-12-11-30	
[REDACTED]		Manufactured	No			100	Each	3.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438	B90927	3							
				52480		3							
[REDACTED]		Manufactured	No			100	Each	7.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
				85185		7							
[REDACTED]		Manufactured	No			100	Each	16.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16							
				52481		16							
[REDACTED]		Purchased	No			180	Each	82.0000	1	4		11-12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82							
				111064		82							

# Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

MS27039-1-10

Purchased No

180

Each

416.0000

8

32

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Screw

## Location

## Loc Qty

## Loc Code

308	123522	8
	122441	8
GA		100
	120449	100
ST291		5
	120120	5
ST305		300
	122815	300
ST308		3
	122027	3

168

12.12.19

NAS1149D0316J

Purchased No

180

Each

400.0000

8

32

Washer

## Location

## Loc Qty

## Loc Code

ST298		400
	122151	400

168

12.12.19

NAS1149D0363J

Purchased No

180

Each

4,785.0000

8

32

Washer

## Location

## Loc Qty

## Loc Code

ST294		1854
	123248	1254
	123355	600
ST297		2820
	122378	2820
ST298		111
	117601	61
	119537	33
	120308	17

168

12.12.19